

# Work Order ID 56749

March 8, 2010 9:18:25 AM



Page 1

Item ID: D2573

Accept



Setup Start



Revision ID:

Item Name: Saddle, Aft Out 205

Stop



Start Date: 09/03/2010 Start Qty: 8.00

Required Date: 23/03/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

*10.03.04*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *56749* Double check by: *mf* ☐ 1-Machine Step No 1  
per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2  
per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3  
per Folio FA051 and insp

*DTT 10/03/10*

*8 0*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

*mf 10/03/10*

*8 0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*mf 10/03/10*

*8 0*



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Page 2

Item ID: D2573

Accept



Setup Start



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Stop



Item Name: Saddle, Aft Out 205

Start Date: 09/03/2010 Start Qty: 8.00

Required Date: 23/03/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

218 10/03/22

✓ 0

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

41 10/03/22

(18) 0

Memo

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

⇒ 10/03/23

(15) 0

Memo

0.00

START TIME:

10:00AM

FINISH TIME:

9:30AM

OVEN TEMPERATURE:

320°F





# Work Order ID 56749

March 8, 2010 9:18:25 AM



Page 3

Item ID: D2573

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 09/03/2010 Start Qty: 8.00

Required Date: 23/03/2010 Req'd Qty: 8.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BK

10-3-23

(8)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 57

Memo

0.00

0.00

934

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/03/23 (8)

10/03/24 (8)

10-3-23 (8)

100

100

100

100

100

100

100

100

100

# Picklist Print

March 8, 2010 9:18:25 AM

Page 1

Work Order ID: 56749

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205


Comments: IPP: I As Per RevE 06-01-27 JLM

Start Date: 09/03/2010

Required Date: 23/03/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	74.0000	8.0000			
												
Saddle Billet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	74	
41960	1	
46412	73	

8 DIT 10/03/16





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<u>52749</u>
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	.440	.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.004	8.004	8.004		
F	0.490	0.510		0.503	0.496	.500	0.508		
G	0.257	0.262		0.259	0.259	0.259	.259		
H	0.375	0.380		0.377	0.377	0.377	.377		
I	0.490	0.510		0.499	0.503	.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.565	0.567	.564	0.5		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.124	0.125	0.124	.124		
Q	0.115	0.135		0.135	0.135	.135	0.135		
R	0.240	0.260		0.250	0.252	0.252	0.252		
S	0.115	0.135		0.130	0.128	.125	.123		
T	0.178	0.198		0.188	0.188	0.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.230	0.240	.240	.240		
W	0.115	0.135		0.130	0.130	.130	.129		
X	0.308	0.313		0.311	.311	.311	0.3105		
Y	0.760	0.765		0.760	.761	.761	0.762		
Z	0.352	0.372		0.364	.360	.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	.500		
AB	0.615	0.635		0.626	.629	.630	0.626		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.250	0.250	.250	.250		
AE	1.500	1.520		1.515	1.516	1.515	1.515		
AF	0.115	0.135		0.130	0.130	.115	.135		
AG	0.240	0.280		0.270	0.270	0.270	.270		
AH	0.240	0.260		0.244	0.246	.246	.248		
AI	2.000	2.020		2.003	2.005	2.003	2.004		
AJ	0.023	0.043		0.033	.033	.033	.033		

Accept/Reject

Measured by:	<u>[Signature]</u>
Date:	<u>10/03/10</u>

Audited by:	<u>[Signature]</u>
Date:	<u>10/03/22</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 56749
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
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Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

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				15	16	17	18		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.004		
F	0.490	0.510		0.501	0.510	0.507	0.508		
G	0.257	0.262		0.260	0.260	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.502	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.569	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.369	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.125	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.127	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.252	0.253		
S	0.115	0.135		0.125	0.1275	0.128	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	0.238	0.237	0.236		
W	0.115	0.135		0.129	0.1275	0.128	0.130		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.362	0.362	0.362	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.627	0.628	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.250	0.247		
AE	1.500	1.520		1.517	1.5165	1.5165	1.517		
AF	0.115	0.135		0.125	0.135	0.135	0.130		
AG	0.240	0.280		0.277	0.271	0.270	0.270		
AH	0.240	0.260		0.244	0.244	0.245	0.244		
AI	2.000	2.020		2.006	2.0045	2.0045	2.006		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: MW	Audited by: JF
Date: 10/03/20	Date: 10/03/22

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E	05.12.05	Added dimension AJ	KJ/JLM	





05.12.06 H

